

Work Order ID 86003

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Now
86003

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Item ID: D4202-1

Revision ID:

Item Name: Spacer

Start Date: 6/19/12

Start Qty: 300.00

300

Required Date: 6/20/12

Req'd Qty: 300.00

300

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4202	C

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

1- Machine as per Echo FB015

FOLIO REV: *8/8*

DWG REV: *C*

2- Deburr

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

29 12-6-19

431 4

29 12-6-17

431 4

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Item ID: D4202-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer
 Start Date: 6/19/12 Start Qty: 300.00 *300* Cust Item ID:
 Required Date: 6/20/12 Req'd Qty: 300.00 *300* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Outsource process - Heat Treat	0.00							
130									
Outsource1	Memo	0.00							
Outsource process - Heat Treat	***HEAT TREAT AS PER DWG D4202***								
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	Memo	0.00							
Packaging									

B-A 12/06/21

431

D/O: 17280

CL 12106/22 300
431

12/17/9 431

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Item ID: D4202=1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer
 Start Date: 6/19/12 Start Qty: 300.00 *300* Cust Item ID:
 Required Date: 6/20/12 Req'd Qty: 300.00 *300* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- Inspect dimensions to drawing	0.00							
150		0.00							
QC	Memo								
Quality Control									
190	Identify as per dwg & Stock Location: LG	0.00							
190		0.00							
Packaging	Memo								
Packaging	***STOCK IN SKIDTUBE CELL***								
200	QC21- Final Inspection - Work Order Release	0.00							
200		0.00							
QC	Memo								
Quality Control									

CK 12/7/10
 MF 12-07-09

Picklist Print

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Work Order ID: 86003

Parent Item: D4202-1

Parent Item Name: Spacer

Start Date: 6/19/12

Required Date: 6/20/12

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD verf:EC

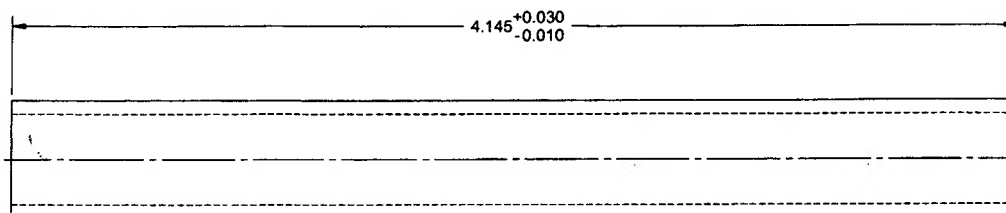
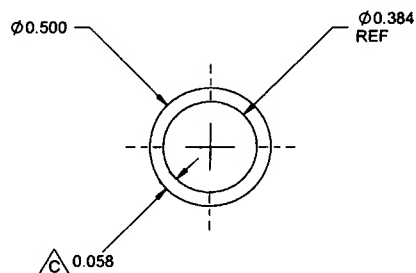
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	513.5430	0.35	110.52632			
6061-T6 RD Tube .500 x.058W													

Location	Loc Qty	Loc Code
MAT014	513.543	
117084	23.242	
117890	0.1	
119160	1.914	
120935	188.287	
122051 ✓	300	

29 2.6.9

~~141~~ 161.334

6 lengths 12'
 +
 6 lengths 12'
 6 L 12'
 216
 - 54.666
 161.334
 (remainder cut out 1)



D4202-1 SPACER

86003

RELEASED
2011-12-14
MP

- NOTES:**
- 1) MATERIAL: 6061-T4/-T42 ALUMINUM TUBING PER WW-T-700/6, AMS 4081, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T4T0.500W.058
OR
6061-T6/-T62 ALUMINUM TUBING PER WW-T-700/6, QQ-A-200/8, QQ-A-225/8, AMS 4080 / 4082, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T6T0.500W.58
HEAT TREAT TO -T4/-T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.03 lbs

C	6061-T4 WAS 6061-T6, 0.058 WAS 0.049	CP	11.12.13
B	0.049 WAS 0.058. REASON: FACILITATE MFG	MB	11.03.22
A	NEW ISSUE	CP	10.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	11.12.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4202	REV. C SHEET 1 OF 1
TITLE SPACER	SCALE NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17280

Purchase Order Date 6/22/12

PO Print Date 6/22/12

Page Number 1 of 1

Order From :

VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Contact Name

Vendor Phone

450 473 1884

Vendor Fax

450 491 5498

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
6/22/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	86003	D4202-1 SPACER	7/02/12 Yes	431.00	FedEx PI collect	\$1.2500	\$538.75

Special Inst: HEAT TREAT TO CONDITION T4 OR T42
MIN. UTS = 30 KSI (60 HREW MIN.)

PO Total:

\$538.75

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

Change Nbr: 2

Change Date: 6/22/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Recu de Livraison

Order	Shipper	Shipping Seq.
177207	1	62364

Shipped Complete

Customer **215**

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Shipped To:

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
PO17280		AL-6061	2012/6/26	FEDEX
Quantity	Part No. / Part Name / Part Description			Pounds
431	D4202-1 REFERENCE 86003 SPACER			14,

CONTENANT: 1 BOÎTE DE CARTON

Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

PACKING	
----------------	--

Quantity Shipped: 431
Pounds Shipped: 14,00
Quantity Remaining: 0
Pounds Remaining: 0,00

Quantity Shipped: 431

Pounds Shipped: 14,00

Signature:

Date:



Metcor Inc.
560, boul. Arthur-Sauvé
St-Eustache (Québec) J7R 5A8
Tél. : 450 473-1884
Télécopieur/Fax administration : 450 491-5498
Télécopieur/Fax production : 450 491-6454

Certificat de Conformité
Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
177207	1

CLIENT / customer: 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY ON K5A 1K7

LIVRÉ À / shipped to:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY ON K5A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT matl heat code	NUMÉRO DE LOT lot number
PO 17280		AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ
processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42 *S1767109*

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	35 - 43 %IACS	50	38 - 39 %IACS
HARDNESS	80 HREW MIN	80	88 - 72.5 HREW
DURETÉE MESURÉE EN HR15TW = 87-89 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
434	14	D4202-1 REFERENCE 88003 SPACER CONTENANT: 1 BOÎTE DE CARTON

COMMENTAIRES / comments

INSPECTEUR / inspector:

[Signature]



DATE: 2012-07-04